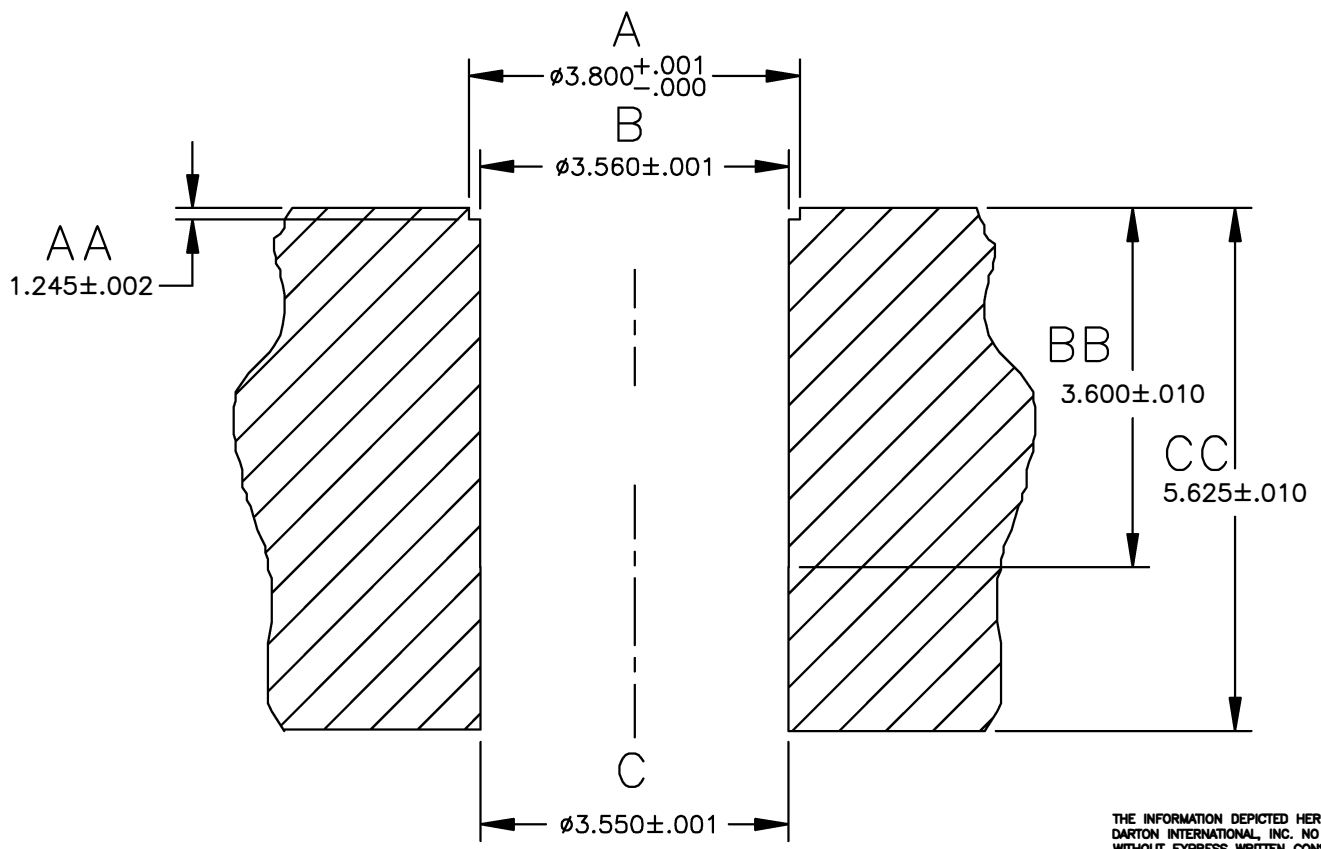



REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL



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DR. BY: H Cruz	 Darton International, Inc. Carlsbad, CA USA (800) 713-2786 (760) 603-9895 FAX (760) 603-9629 WWW.DARTON-INTERNATIONAL.COM
DATE: 6/19/13	
CHKD BY:	TITLE: BLOCK SPECIFICATION- 2JZ TOYOTA 85/87mm
MATERIAL:	SIZE: A
HARDNESS:	DRG NO.: 300-055 SF/DF A
SCALE: 1/2	SHEET: 1 OF 2

NOTE:

LOCTITE #518

- TEMP. RANGE: -65 TO 300 DEG. F
- SPECIFIC GRAVITY; 1.13
- CHARACTERISTICS: RIGID, THIXOTROPIC, GENERAL PURPOSE
- COLOR: RED
- FULL CURE: 4 HR.
- FLASH POINT: 212 DEG. F
- BEGINS TO HARDEN: 30 MIN.
- APPLICATION: METAL THREADS, STEEL AND BRASS, FITTINGS, PIPES, VALVES, GAUGES, REFRIGERANT SYSTEMS, STEM
- TYPE: ANAEROBIC
- SUBSTRATES: METAL
- ITEM: GASKET SEALANT
- VISCOSITY: PASTE
- COUNTRY OF ORIGIN: UNITED STATES (SUBJECT TO CHANGE)


LOCTITE #620

- REQUIRES: SECONDARY HEAT CURE AT 356 DEG. F. TO GENERATE HIGH TEMP. RESISTANCE
- SHEER STRENGTH : 3800 (PSI)
- MAX. TEMP.: 450 DEG. (F)
- APPLICATION: SHAFT MOUNT, SLIP FIT
- TYPE: HIGH TEMP.
- FULL CURE: 4 HR.
- COMPOUND TYPE: HIGH VISCOSITY, HIGH TEMP. ADHESIVE
- STANDARDS: CFIA LISTED
- FILLING GAO SIZE: UP TO 0.015"
- PRIMER: N 7649 TO SPEED CURE ON INACTIVE METALS
- ITEM: RETAINING COMPUND
- (USING LOCTITE #620 AS A HEAT TRANSFER MAY MAKE IT DIFFUCULT TO REMOVE SLEEVE)
- (WE DO NOT SUPPLY #620 LOCTITE)

NOTE:

1. MACHINE DIMENSION A AT NET TO .002 CLEARANCE.
2. MACHINE DIMENSION B AT NET TO .0005 PRESS FIT.
3. MACHINE DIMENSION C AT .0005 TO .001 PRESS FIT.
4. APPLY LOCTITE #518 OR #620 TO BLOCK BORE AT C DIMENSION.
5. MACHINE BLOCK AT BORE CENTERS OF 93mm/3.6615
6. INSTALL SLEEVES AT ROOM TEMPERATURE AND CLAMP SLEEVES DOWN AT DECK UNTIL LOCKTITE HAS CURED, THEN DECK AND HONE
7. NEW BLOCKS NEED TO BE VIBRATORY STRESS RELIEVED PRIOR TO DECKING AND HONING
8. DO NOT PRESSURE WASH BLOCK AFTER INSTALL
9. MAKE SURE NOT TO GET LOCKTITE ON FLANGE AREA

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL

DR. BY:	CAD DEPT		Darton International, Inc.	
DATE:	3.29.18		Carlsbad, CA USA (800) 713-2786 (760) 603-9895 FAX (760) 603-9629 WWW.DARTON-INTERNATIONAL.COM	
CHK'D BY:		TITLE	BLOCK SPECIFICATION - 2JZ TOYOTA 85/87mm	
MATERIAL:		SIZE	A	REV
HARDNESS:		DWG. NO.	300-055-SF-DF	A
		SCALE	1/2	SHEET 2 OF 2